

## ABSTRACT OF THE DISCLOSURE

A feed table with force reaction system for counteracting clamping forces on a shuttle vise used to move a workpiece toward a machine tool. In a first embodiment, lever arms are attached to an upper guide rail between two vertical columns. A reaction actuator interconnects upper ends of the lever arms such that when actuated, a reaction force is applied to the vertical columns by lower ends of the lever arms to counteract clamping forces created by a clamping actuator attached to one of the vertical columns. In a second embodiment, lever arms are also used and interconnected at the upper ends thereof by a reaction bar. A reaction actuator is attached to a lower end of each of the lever arms to apply the reaction force. In third and fourth embodiments, a clamping force bar is positioned above the upper guide beam. A clamping actuator is attached to the clamping force bar such that clamping forces are not transmitted to the vertical columns.